

Date: Wednesday, 3/7/2007 8:38:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3" OUTER TUBE
Job Number : 31032	
Estimate Number : 10796	
P.O. Number : <i>N/A</i>	Part Number : D26001190
This Issue : 3/7/2007	Drawing Number : D2600 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : D1
Previous Run : 24841	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/20/2007
Checked & Approved By : <i>[Signature]</i> 07.03.07	Qty: 80 Um: Each
Comment : Est Rev.A 99.08.18 Was 2600-1 added -240 for length EC	
Est Rev.B 07.02.28 Changed length to -190 LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	-PURCHASING
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Comment: PURCHASING

Issue P/O: *3263*

a) Extrude as per Dwg D2600 (190" long)

b) Material: 6061-T6

c) Tool: MH-18870 *Ben L #997121*

d) Material certification is required.

2.0	D26001190P	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)

Extrusion Round 3" 206

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *L6**JB 7-8-18*

Dart Aerospace Ltd.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 31032

Part Number: D26001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(82)

Comment: FINAL INSPECTION/W/O RELEASE

D2600119

Job Completion



U 07-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DAK</i>	DRAWN BY <i>DAK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DAK</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>4 GP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

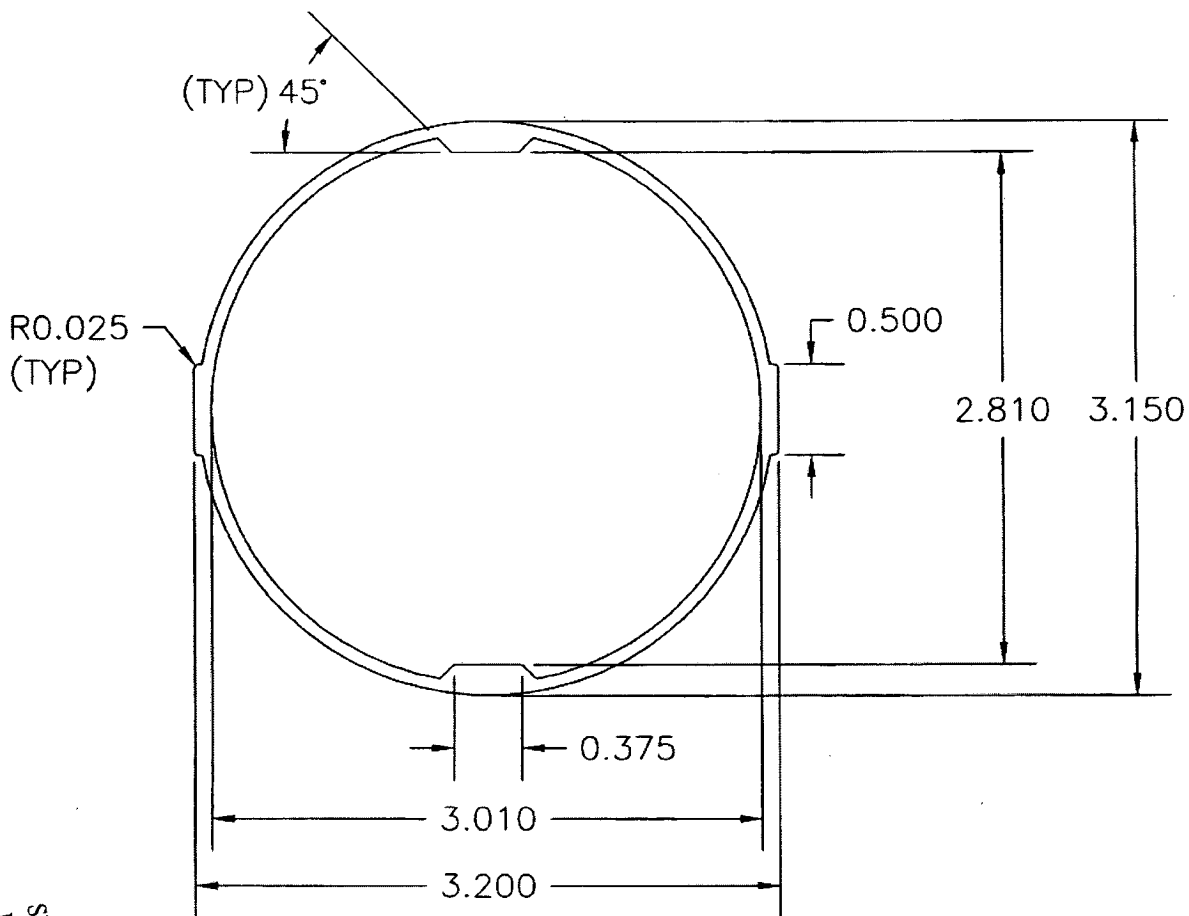
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31032

DART



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
DATE	98.08.20			D2600	SHEET 2 OF 5
				TITLE	SCALE
				EXTRUSION	1:1

RELEASED
98.8.25 DS



D2600-1

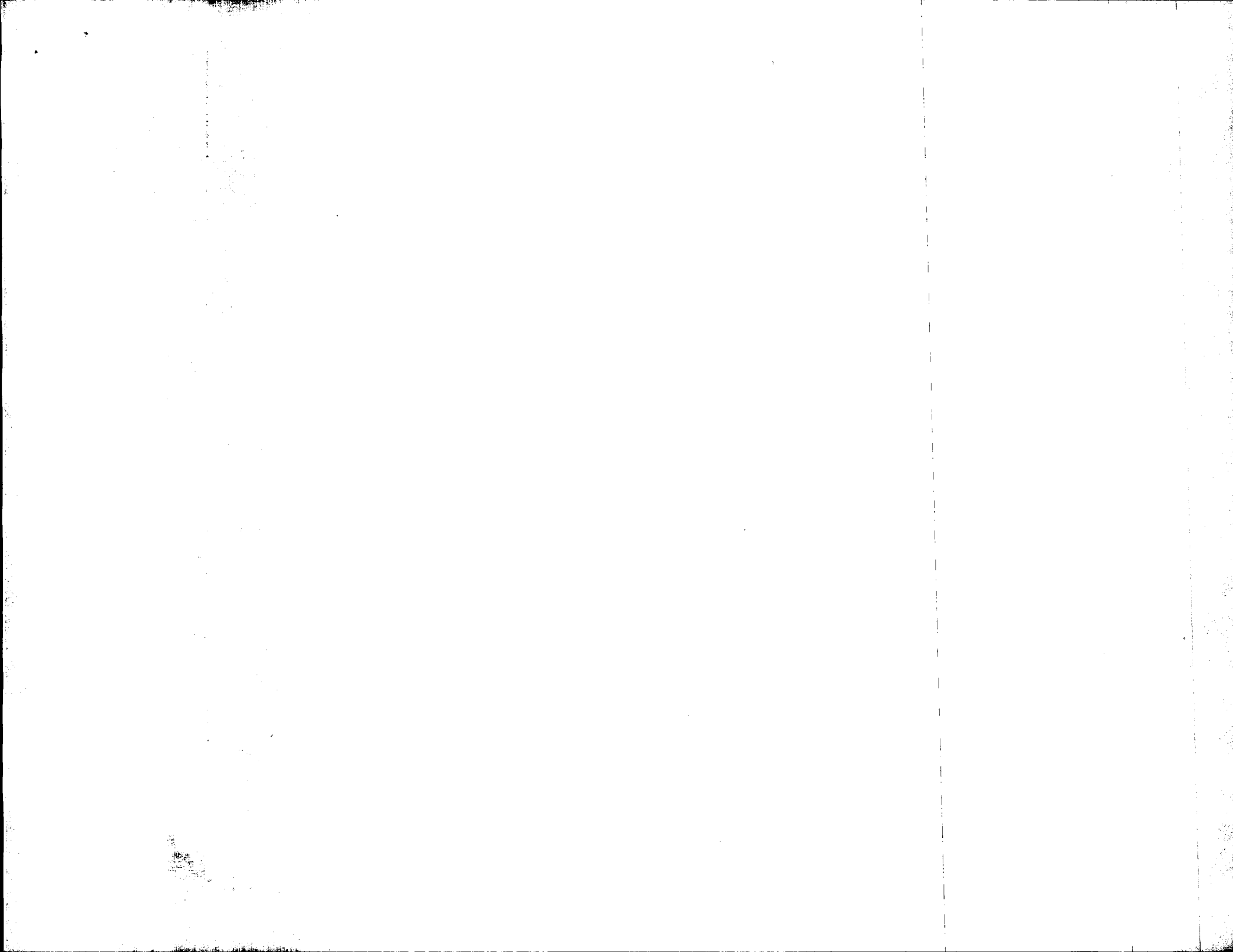
MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

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WITHOUT NOTICE



WORK ORDER
NO. 31032

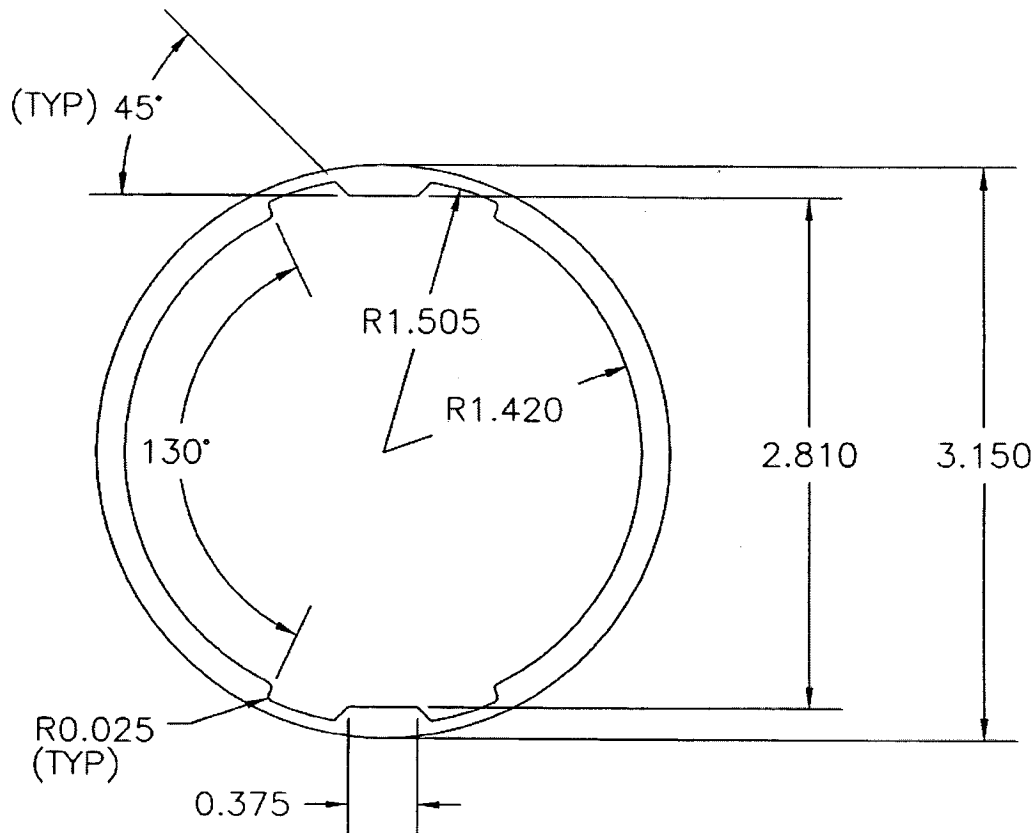


DART



DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5	
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1	

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

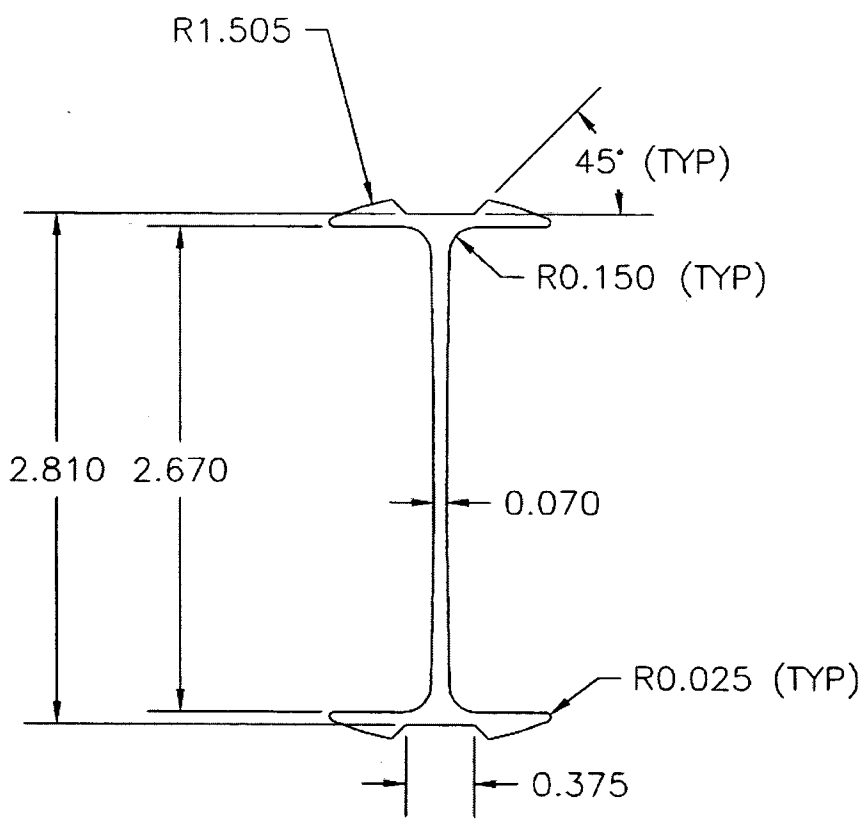


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WORK ORDER
NO. 31032



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600
DATE 98.08.20	TITLE EXTRUSION	REV. D SHEET 4 OF 5 SCALE 1:1

RELEASED
98.8.25 DS

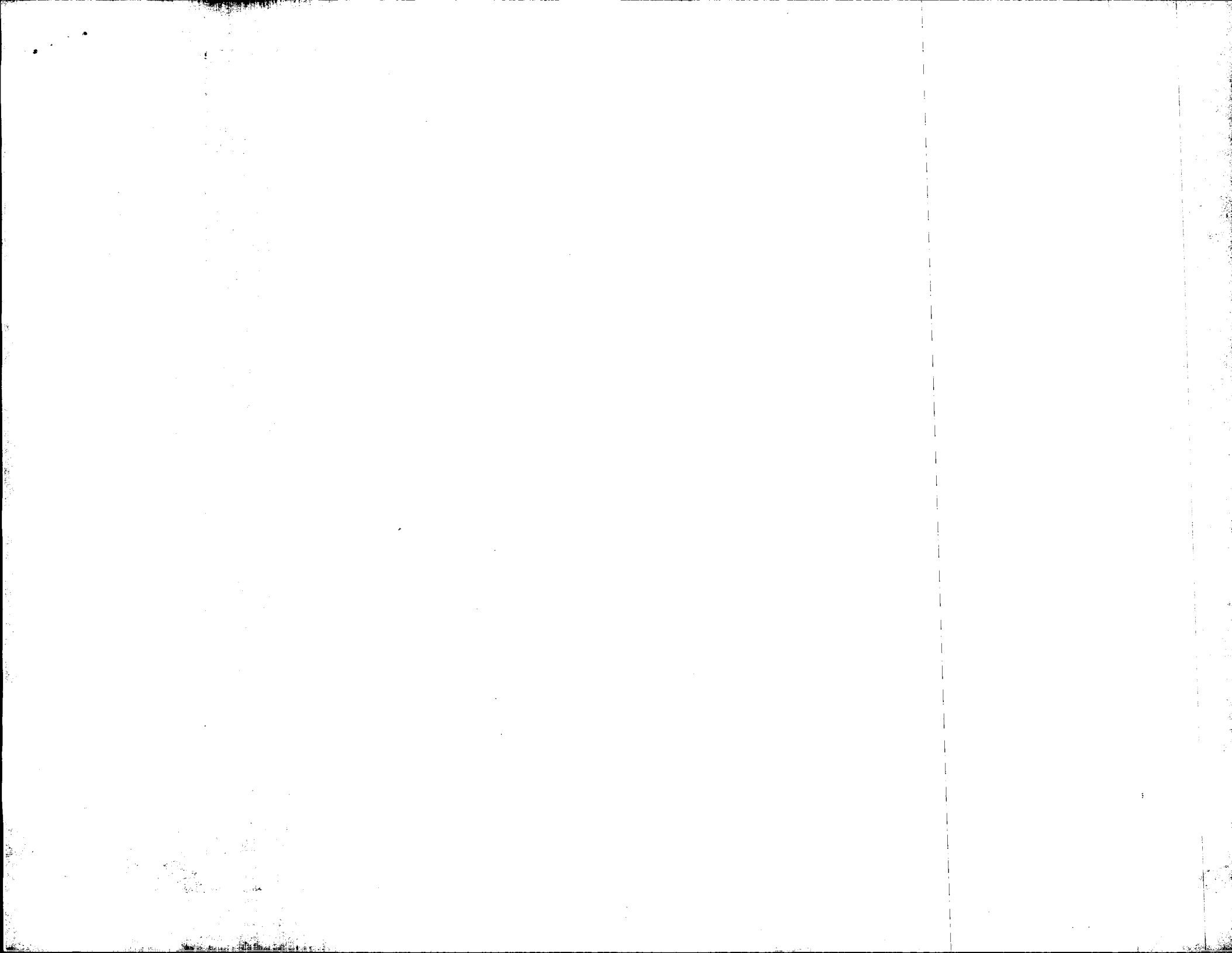


D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



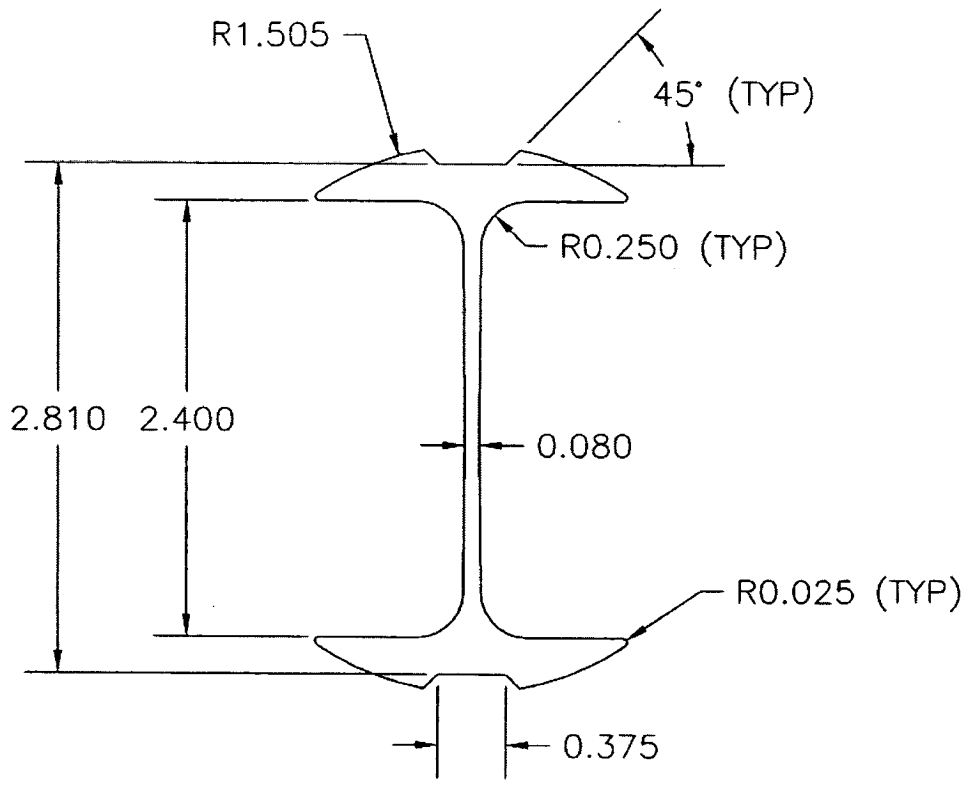
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WORK ORDER
NO. *31032*





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE		D2600	SHEET 5 OF 5
98.08.20		TITLE	SCALE
		EXTRUSION	1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



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WITHOUT NOTICE

WORK ORDER
31032

**BON L CANADA INC**

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Part Date	Part No.	Sales Order	Page
08/03/07	163764	79932	1
Part ID	P/L No.	Lot	Date
4249	00352652	79932010	8/03/07
Sold To		Ship To	
46024		46024	
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-3	190" Mill 6061 T6	D2600-1-190
Gross Weight	656 KGS		
Net Qty	628 KG	82 PC	396 M
			2 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-00		

Mechanical Tests:

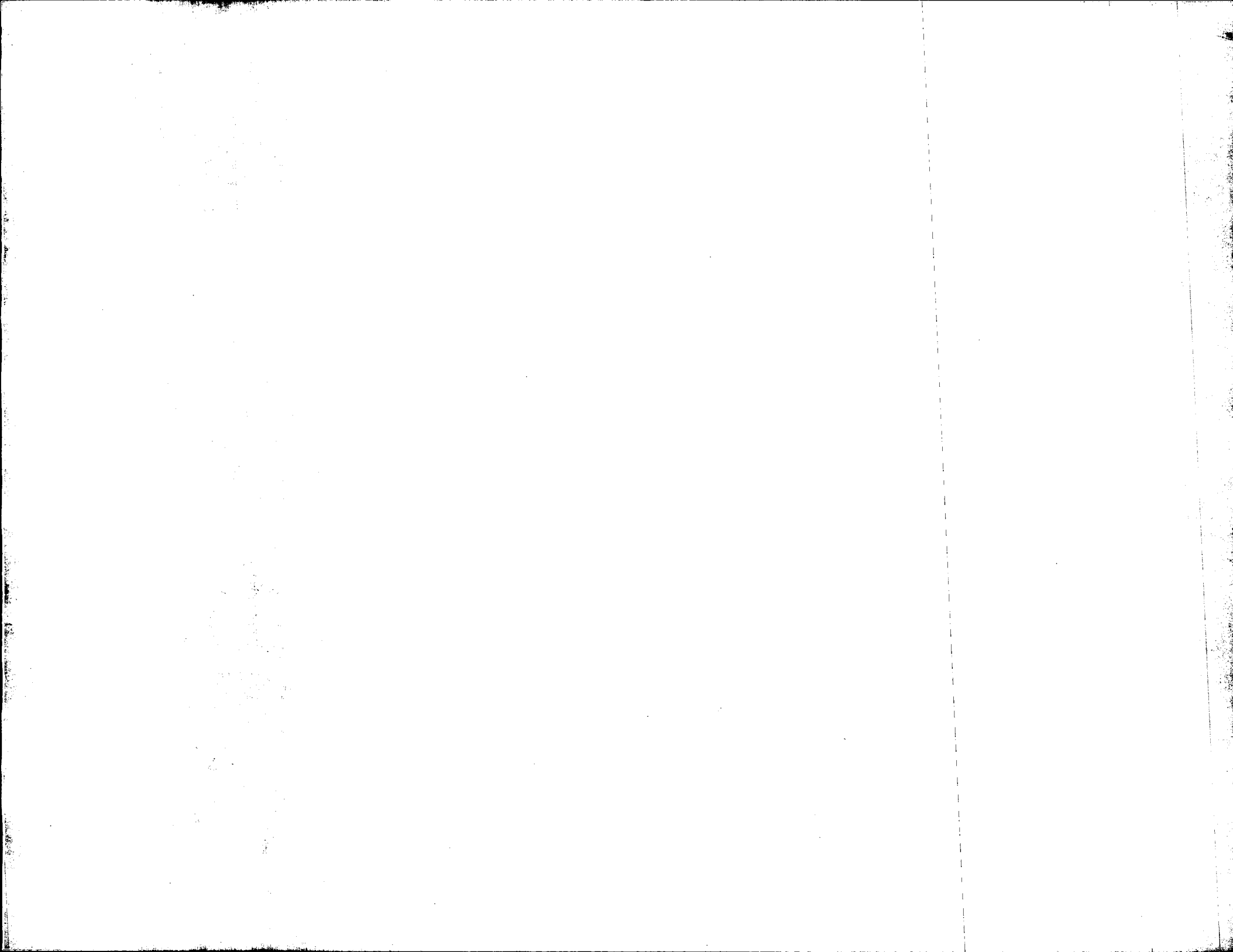
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	275.9 / 40.0	213.1 / 30.9	11.5	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada



BON L CANADA INC.

WILLIAM L. BONNELL COMPANY, INC.
IN L MANUFACTURING COMPANY
SUBSIDIARIES OF TREDEGAR CORPORATION
FILIALES DE LA CORPORATION TREDEGAR



INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

L4C 4Y9

SHIPPING MANIFEST BORDEREAU D'EXPEDITION

ACCT# 00046024
DIE A

OSPACE LTD.
RDEEN ST.
RY

ON
CN

SOLD TO/ENDU A

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON
CN

O/P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

MANIFEST DATE/DATE D'EXPÉDITION

MANIFEST NUMBER/N° D'EXPÉDITION

SALES ORDER NUMBER/N° DE COMM.

CREDIT REP
REP. DU CRÉDIT
HAMBROOK, PAU
905-508-3250

SALES REP
REP. DES VENTES

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

3-632-5200

PHONE 613-632-5200

RIH

OTTAWA

59358

ENT ORDER DATE DATE DE LA COMMANDE CUST. PO. NO./N° DE COMM. DU CLIENT JOB/PROJET

07/25/07 4249

BILL OF LADING NUMBER/N° DE CONNAISSEMENT

00352652

JANITY VANDÉE	UNIT UNITÉ	PREVIOUS SHIPPED QTY QTE DÉJÀ EXPÉDIÉE	MFG. PART NUMBER N° DE PIÈCE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPÉ	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITÉ	QUANTITY DUE QUANTITÉ PRÉVUE
						NO. PKGS N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
80	KG	0	DAA-897121-3	6061 /T6	MILL	2	656	628	KG	0
	M	0	D2600-1-190	190"	CERTIFICATE OF COMP			395.73	M	0
	PC	0		+5/16 "	(+015-015,0092-0068)			82	PC	0
			DETAIL; LOT/TICKET		79932010 / 174557	1	411	395		51 PC
					79932010 / 174559	1	245	233		31 PC

S WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER
CLIENT

2 656 628 KG
395.73 M

70001
Cert No: 163764

Certificate of Compliance

Page - 1
Date - 8/27/07

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date. . . 08/03/07

Sales Order. . . 79932
Cust PO. . . 4249
E/L No. . . 00382652
Lot. . . 79932010

Sold to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Ship to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

Item Number	Part Number	Item Description	Gross KGS	Net Quantity
1.000	DAA-897121-3	190" Mill 6061 T6	656	628 KG 82 PC 396 M 2 PKG

Cust part: D2600-1-190
Specification: AMS-QQ-A-200/8 & ASTM B221-00

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	324.9 / 47.1	286.9 / 41.6	10.4	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	CA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

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